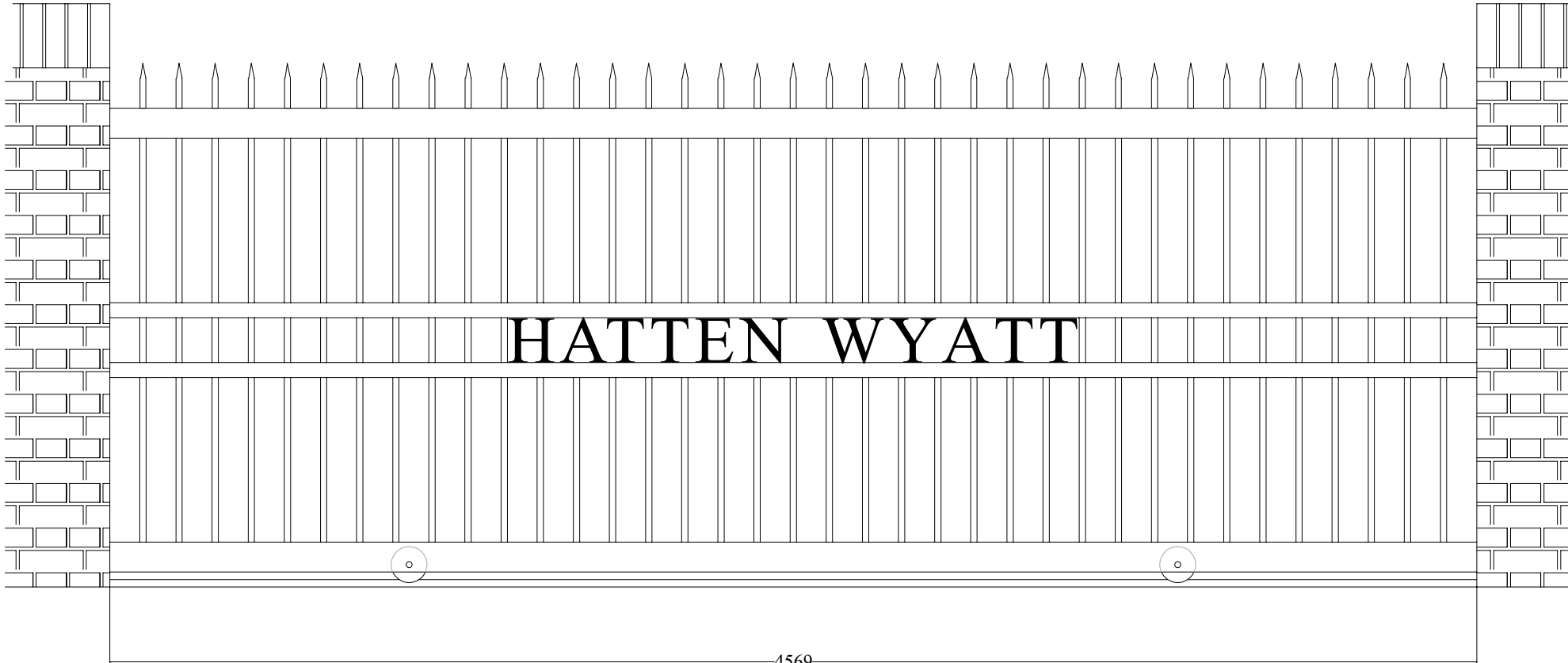


Welding Specification
All welds to be 6mm Filler welds UNO
All welding to be performed in accordance to an approved WPS
BS EN 1090-2-Execution Class 2

Weld Finish
As welded (Unless stated otherwise)

Weld Testing
100% visual inspection
Minimum NDT requirements as per table 24 (BS EN 1090-2)

Fixings
All bolts & studding to be grade 8.8 375N/mm² to EN 14399 UNO
All externally exposed Bolts,Nuts & washers to be spun galvanised

Material
Steelwork grades as follows
General Structural Sections to be BS EN 10025-1 Grade S3555 JR
Plates/Connections BS EN 10210: Grade S275JR

Finishes
None, UNO

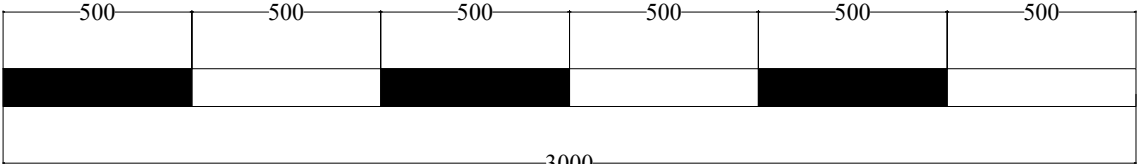
Quality Control
All dimensions are in millimetres unless specified otherwise
All levels are in metres and relate to ordinance datum, UNO
All works to be carried out in accordance with
ISO 1090 BS EN 1090-2:2008 + A1:2011, and in accordance with
specialist drawings for verification of all setting out dimensions and
location of services or fixings required in the steel & concrete works

Manufacture Tolerance
General dimension < 1000mm +/- 1mm, > 1000mm +/- 3mm
location of web stiffeners ^ = +/- 5mm
Holing tolerances

All burnt profiled plates to have 'troughing' removed from all edges
Plate/cut edges to have 'arrised' corners to approx 1.5 to 2.5mm radius
Weld spatter to be removed during fabrication and on completion
Remove all sharp edges and burrs
Drilled & tapped connections into hollow sections are to be avoided
Closed sections and troughs to have drain and vent holes as necessary

Workshop Note
Make it to drawing- if you suspect a drawing error, stop and report it to
your supervisor for immediate remedy

100 x 50 x 5 RHS Perimeter Frame
50 x 50 x 5 Intermediate Horizontals
21 CHS Balusters
150 High Lettering
Powder Coated Finish



General Notes		
1	Powder Coated	
2		
3		
4		
5		

For Manufacture		
Name	GH	Date 29/6/23

Decorative Iron Services, Dartford, DA2 6EP. Telephone 01322276451, Email, admin@decorativeironservices.co.uk					
Client TES Construction			Contract 51-54 Windmill Street Gravesend		
			Description Proposed Gate		
Drawn By G.Hand	Date 29/06/23	Scale 1:20 @ A3	Job No	DRG No 001-01	Rev /